Work Order ID 110477 *110477*

December-20-13 9:18:09 AM

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 13-12-20 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							mhd
100 DC Document Control	Memo	0.00							

Draw Nbr	Revision Nbr
D2750-042	G
D3492	C

sf

DD 14-1-28

record fwd angle: 89.2°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS 31 ~~9-99~~ 14-02-21

B110477RH

Work Order ID 110477

December-20-13 9:18:09 AM

110477

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1*

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1*

Reference:

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	Skidtubes								
Skidtubes		0.00							
Skidtubes									

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8-Open up holes for Detail "K" to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail J to 0.297" (total of 2 holes per side)

14-1-28

Work Order ID 110477

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110477

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M127069 BE 14-01-29 12-Grind welds flush as per Dwg D2750 BE 14-01-29								
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00				1	14-01-29		DAS 9 9-89
	Memo	0.00							
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				1	14-01-29		DAS 9 9-89
	Memo	0.00							

Work Order ID 110477

December-20-13 9:18:09 AM

110477

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140 HandFinish	**Memo**	0.00				DC	14/01/29		
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150 QC	**Memo**	0.00				DP	14-1-29		
Quality Control									

Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes								
Skidtubes		0.00							
Skidtubes									

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

DC 14/01/29

7-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: 127097
exp. date: 14/02/16

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)
A/R Aluminum Rod batch: m127069

BEH-01-30

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

DBL 14-1-30

11-Spot face ground handling holes section (total of 4 places per side) as per

Work Order ID 110477

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Item ID: D350-636-012 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750 12-Deburr holes DGL 14-1-30								
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00				1	14-01-31		DAS 9 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo** ***VERIFY C'BOARD IS GOOD***	0.00 0.00				1	14-01-31		DAS 9 9-89

Work Order ID 110477

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Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190						1		14-2-3	
HandFinish	**Memo**	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200						1	C.R.	14-2-13	
SprayPaint	**Memo**	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 126 543 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 128609								
210	QC14- Inspect Spray Paint	0.00							
210						1			14.02.14
QC	**Memo**	0.00							
Quality Control	Inspect for foreign object per QSI 024								

Work Order ID 110477

110477

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Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230 HandFinish	HandFinishing					1RM	6	4	12/02/14
Hand Finishing	**Memo**	0.00							

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: M127918
EXP DATE: 14/09

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M121651

5-Coat all exposed fasteners with "LPS Procyon"
batch: M122900

240	QC5- Inspect part completeness to step on W/O	0.00	SMB 14/12/10			1			
240 QC	**Memo**	0.00							
Quality Control									

Work Order ID 110477

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Item ID: D350-636-012 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00					DAS 28 9-89		
250						1X		14-02-20	
Packaging	**Memo**	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260			DAS 31 9-89	14-02-21			1		
QC	**Memo**	0.00							
Quality Control									
270		0.00							
270	Packaging						DAS 6 9-89		
Packaging	**Memo**	0.00	072			14-2-26			DAS 28 9-89
Packaging	Package as per PPP D350-636-012								

Work Order ID 110477

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110477

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Start Qty:** 1.00 *1*

Required Date: 1/03/14 **Req'd Qty:** 1.00 *1*

Reference:

Accept *N900040100*

Setup **Start** *NS1* **Stop** *NS2*

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run **Start** *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

14-02-27

14-02-27

Picklist Print

[redacted]
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Work Order ID: 110477 *110477*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Required Date:** 1/03/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:I02.09.25Rearranged procedure stepsKJ
IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
AS PER REV F JLM 13-08-22 VERIFIED BY:DD
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	5.0000	1	1			
D2600-3-BENT									**		14-1-28		
Extrusion Bent													
				Location			**Loc Qty**		**Loc Code**				
				LG002	110478		5			1			
					109789		5						
D2744		Manufactured	No			110	Each	52.0000	1	1			
D2744									**		B14-01-29		
Cap													
				Location			**Loc Qty**		**Loc Code**				
				LG001			52						
					100398		28						
					97543		24			1			
D2739		Manufactured	No			160	Each	11.0000	1	1			
D2739									**		DC 14/01/29		
350 I Beam													
				Location	B110835		**Loc Qty**		**Loc Code**	1			
				LG002			11						
					109712		1						
					109973		10						

Picklist Print

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Work Order ID: 110477 *110477*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Required Date:** 1/03/14

Start Qty: 1.00 **Required Qty:** 1.00

D2743 Manufactured No 160 Each 331.0000 8 8

D2743

Crossbolt Spacer

** BE14-01-30

Location	Loc Qty	Loc Code
LG001	331	
106245	9	
107359	68	
107907	122	
109799	132	8

D3490-3 Manufactured No 160 Each 160.0000 4 4

D3490-3

Cross Bolt Spacer

** BE14-01-30

Location	Loc Qty	Loc Code
LG001	160	
103883	14	
105603	3	
107913	63	
109933	80	4

D3490-1 Manufactured No 160 Each 225.0000 4 4

D3490-1

Cross Bolt Spacer

** BE14-01-30

Location	Loc Qty	Loc Code
LG001	225	
107419	57	
109932	168	4

+2 WELD TEST

D3631-1 Manufactured No 230 Each 12.0000 8 8

D3631-1

Washer

** 11/02/18

Location	Loc Qty	Loc Code
FP001	12	B110258
107324	12	

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Work Order ID: 110477 *110477*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Required Date:** 1/03/14

Start Qty: 1.00 **Required Qty:** 1.00

D3791-1	Manufactured	No	230	Each	3.0000	1	1	
D3791-1 Wearpad						**		M 10/02/18

Location		Loc Qty	Loc Code	
FP002		3	B109511	X1
	106144	3		

D3793-3	Manufactured	No	230	Each	11.0000	1	1	
D3793-3 Wearplate Aft						**		M 10/02/18

Location		Loc Qty	Loc Code	
FP001		11	B110066	A1
	104212	11		

MS21043-6	Purchased	No	230	Each	268.0000	4	4	
MS21043-6 NUT						**		M 10/02/18

Location		Loc Qty	Loc Code	
FG		20		
	103693	20		
ST315		248		
	m127255	248		X4

D3794-1	Manufactured	No	230	Each	13.0000	1	1	
D3794-1 Gasket Fwd						**		M 10/02/18

Location		Loc Qty	Loc Code	
FP001		13	B110316	V1
	104620	1		
	108497	5		
	109207	7		

Picklist Print

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Work Order ID: 110477 *110477*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Required Date:** 1/03/14

Start Qty: 1.00 **Required Qty:** 1.00

NAS1611-010	Purchased	No	230	Each	45.0000	8	8	
NAS1611-010						**		M 14/02/18
O-RING								

Location		Loc Qty	Loc Code	
FP001		45	M127813	V
	m126988	45		

D2741	Manufactured	No	250	Each	39.0000	1	1	
D2741						**		DAS 28 9-89 14-02-20
Blade								

Location		Loc Qty	Loc Code	
FG		11		
	100664	5		
	85480	1		
	98323	5		
ST466		28		
	107206	28		IX

DAS 31 9-89

NAS1515H3L	Purchased	No	230	Each	54.0000	4	4	
NAS1515H3L						**		M 14/02/18
Washer								

Location		Loc Qty	Loc Code	
FG		40		
	102472	40		XV
ST297		14		
	124542	14		

NAS1611-013	Purchased	No	230	Each	16.0000	8	8	
NAS1611-013						**		M 14/02/18
O-RING								

Location		Loc Qty	Loc Code	
FP001		16	M127813	V
	125445	16		

Work Order ID: 110477 *110477*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Required Date:** 1/03/14

Start Qty: 1.00 **Required Qty:** 1.00

MS21083C8 Purchased No 250 Each 35.0000 2 2

MS21083C8 **

Nut

DAS 31 9-89

DAS 28 9-89 14-0[illegible]20

Location		Loc Qty	Loc Code	
ST319		35		127813
	m127255	35		

NAS1149D0863J Purchased No 250 Each 991.0000 2 2

NAS1149D0863J **

Washer

DAS 28 9-89

Location		Loc Qty	Loc Code	
FP001		6		
	118078	6		
ST293		185		
	125484	185		2X
ST510a		800		
	125268	600		
	125635	200		

DAS 31 9-89

D3493-1 Manufactured No 250 Each 245.0000 2 2

D3493-1 **

Washer

DAS 28 9-89

Location		Loc Qty	Loc Code	
FG		10		
	97201	10		
ST051		235		
	105613	16		
	107916	60		2X
	109105	159		

DAS 31 9-89

ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM

Picklist Print

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Work Order ID: 110477 *110477*

Parent Item: D350-636-012 *D350-636-012*

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 **Required Date:** 1/03/14

Start Qty: 1.00 **Required Qty:** 1.00

AN8C21A	Purchased	No	250	Each	45.0000	2	2	
AN8C21A						**		
Bolt								

DAS 26 9-89 14-02-20

DAS 31 9-89

Location		Loc Qty	Loc Code	
ST		2		
	123966	2		
ST505		43		
	m127061	43		2x

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

110477 MLJ
13-12-20

RELEASED
2013-08-13

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
   G OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

REV.	DESCRIPTION	BY	DATE
G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	MM	**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G
MFG. APPR.		SHEET 1 OF 11
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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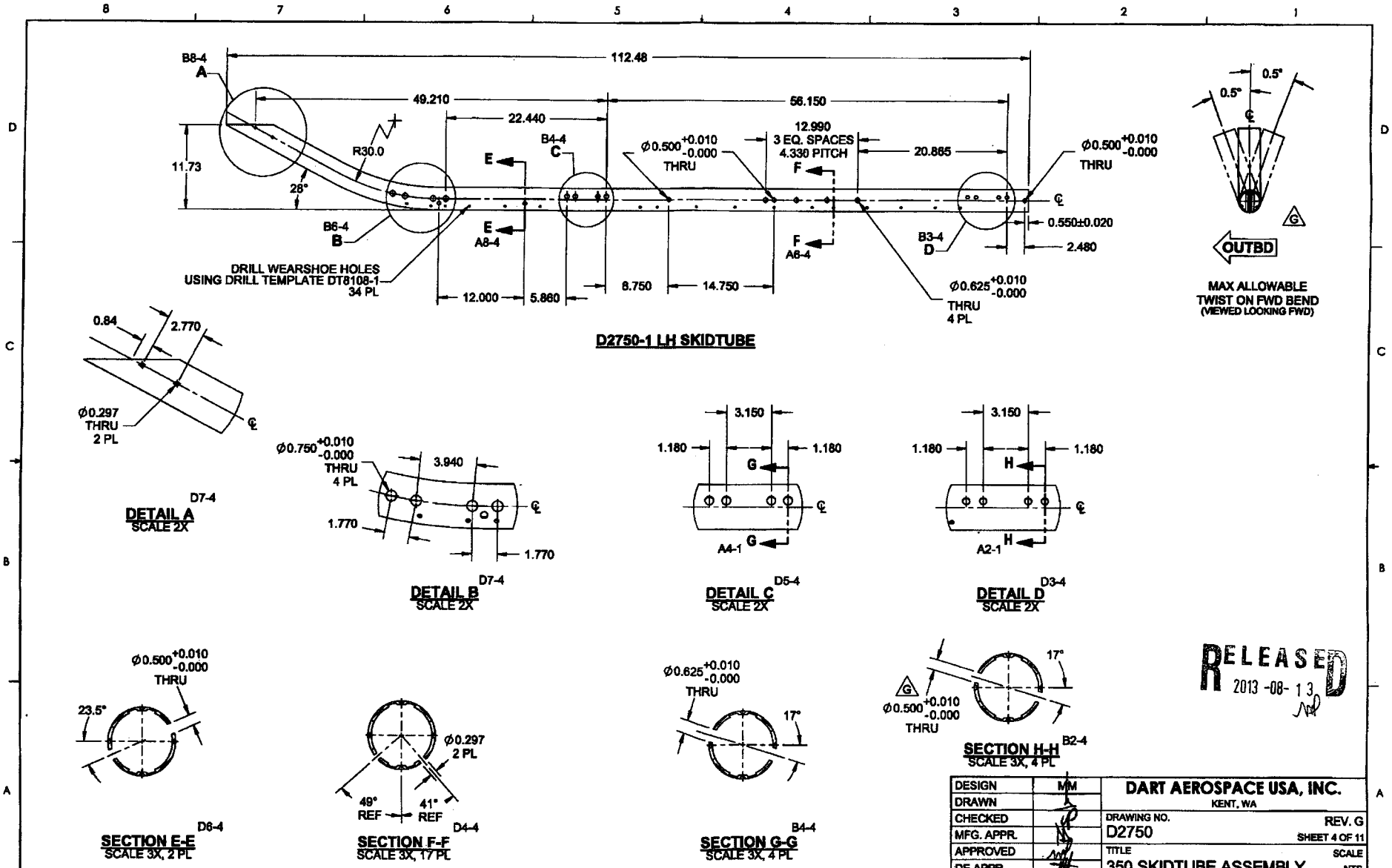
112.48
49.210
56.150
22.440
12.990
3 EQ. SPACES
4.330 PITCH
20.865
11.73
28°
R30.0
B8-4
A
B4-4
C
B6-4
B
E
A8-4
F
A6-4
B3-4
D
Ø0.500 +0.010 -0.000 THRU
0.550±0.020
2.480
DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
34 PL
12.000
5.860
8.750
14.750
Ø0.625 +0.010 -0.000 THRU 4 PL
D2750-1 LH SKIDTUBE
0.5°
0.5°
G
OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)
0.84
2.770
Ø0.297 THRU 2 PL
D7-4
DETAIL A
SCALE 2X
Ø0.750 +0.010 -0.000 THRU 4 PL
3.940
1.770
1.770
D7-4
DETAIL B
SCALE 2X
3.150
1.180
1.180
G
A4-1
D5-4
DETAIL C
SCALE 2X
3.150
1.180
1.180
H
A2-1
D3-4
DETAIL D
SCALE 2X
Ø0.500 +0.010 -0.000 THRU
23.5°
D6-4
SECTION E-E
SCALE 3X, 2 PL
Ø0.297 2 PL
49° REF
41° REF
D4-4
SECTION F-F
SCALE 3X, 17 PL
Ø0.625 +0.010 -0.000 THRU
17°
B4-4
SECTION G-G
SCALE 3X, 4 PL
17°
Ø0.500 +0.010 -0.000 THRU
B2-4
SECTION H-H
SCALE 3X, 4 PL
RELEASED
2013-08-13
DESIGN MM
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 13.07.11
DART AEROSPACE USA, INC.
KENT, WA
DRAWING NO. D2750
REV. G
SHEET 4 OF 11
TITLE 350 SKIDTUBE ASSEMBLY
SCALE NTS
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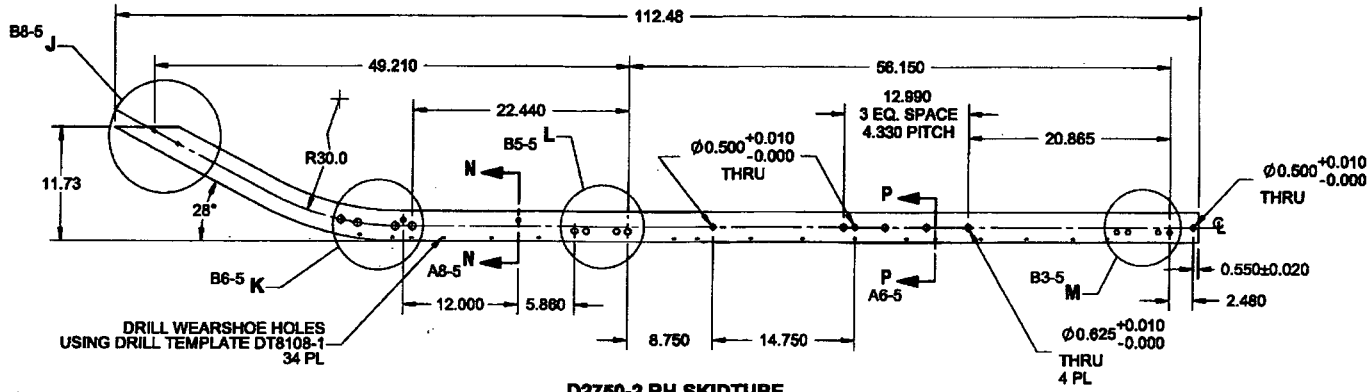
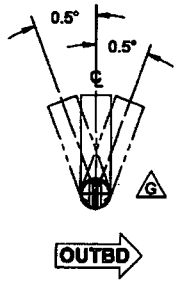
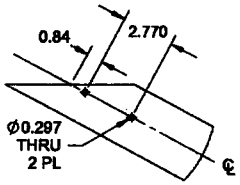


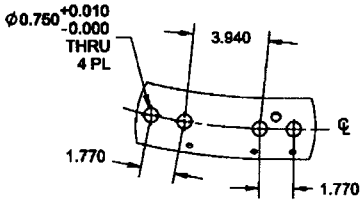
D2750-2 RH SKIDTUBE



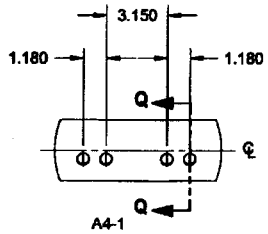
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



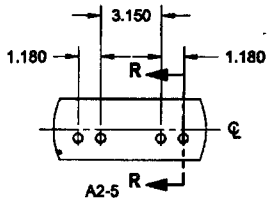
DETAIL J D8-5
SCALE 2X



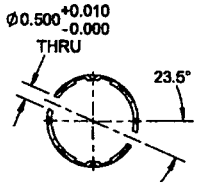
DETAIL K C7-5
SCALE 2X



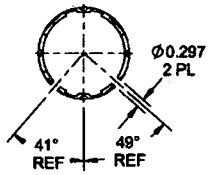
DETAIL L D6-5
SCALE 2X



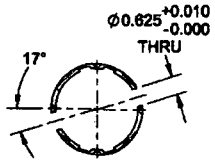
DETAIL M C3-5
SCALE 2X



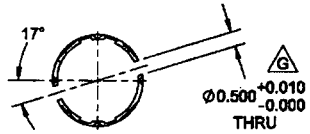
SECTION N-N C6-5
SCALE 3X, 2 PL



SECTION P-P C4-5
SCALE 3X, 17 PL



SECTION Q-Q B5-5
SCALE 3X, 4 PL



SECTION R-R B3-5
SCALE 3X, 4 PL

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CHECKED		DRAWING NO. D2750 — REV. G — SHEET 5 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE	13.07.11	

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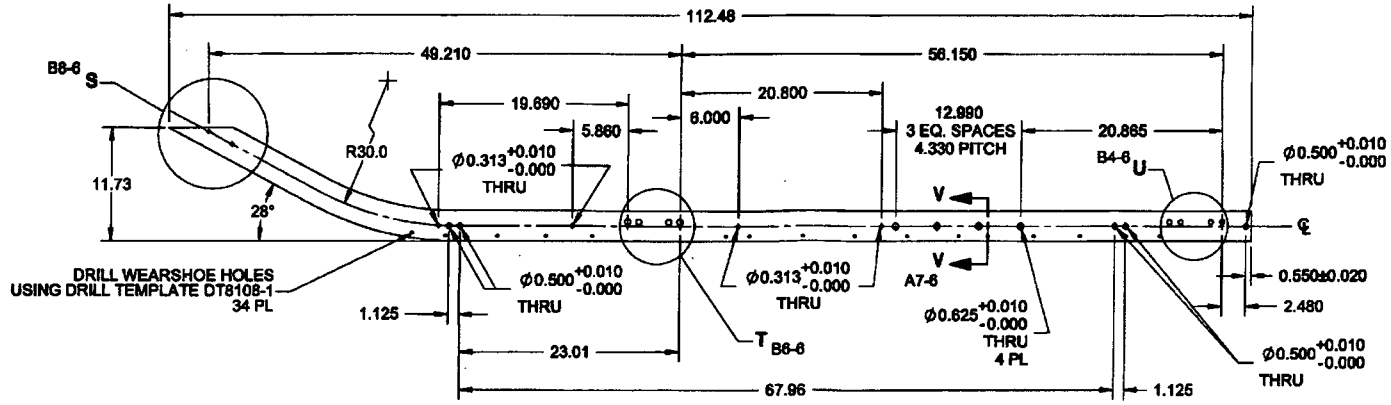
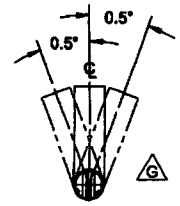
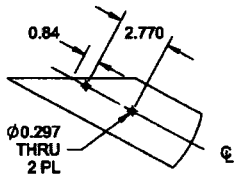


D2750-3 LH SKIDTUBE

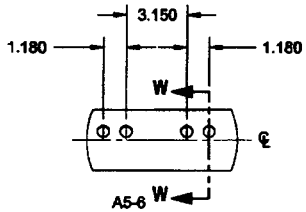


OUTBD

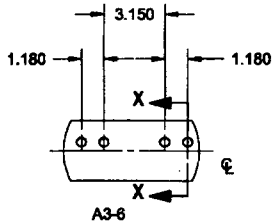
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



DETAIL S D8-6
SCALE 2X



DETAIL T C5-6
SCALE 2X



DETAIL U D3-6
SCALE 2X

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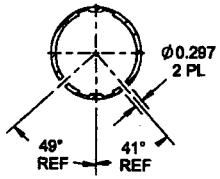
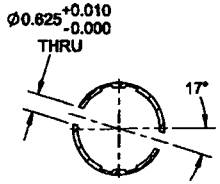
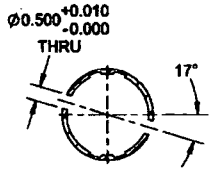


SECTION V-V C4-6
SCALE 3X, 17 PL



SECTION W-W B6-6
SCALE 3X, 4 PL



SECTION X-X B4-6
SCALE 3X, 4 PL

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DRAWN		DRAWING NO. D2750 — REV. G — SHEET 6 OF 11
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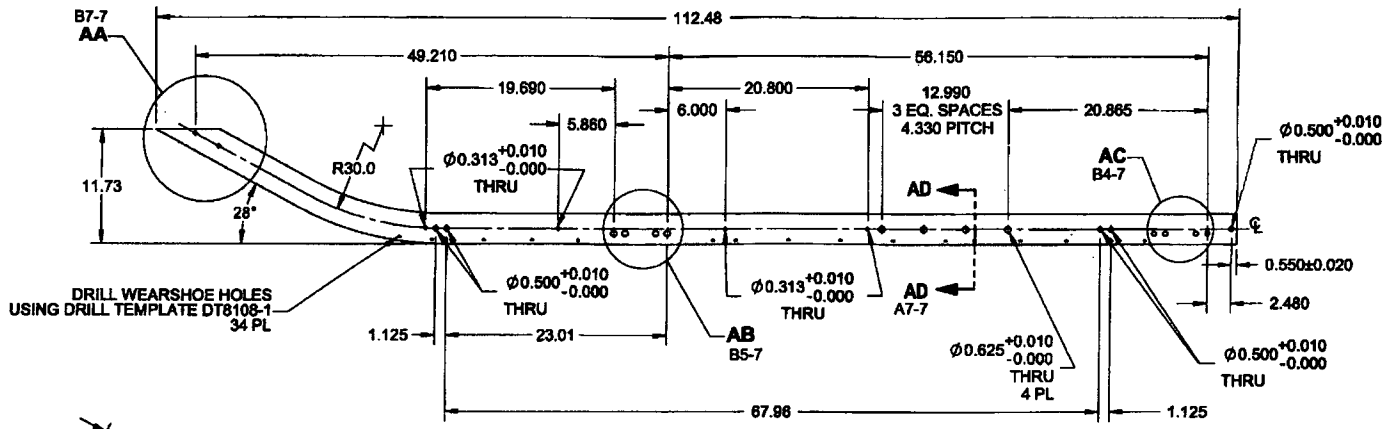
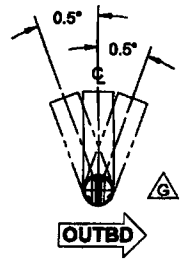
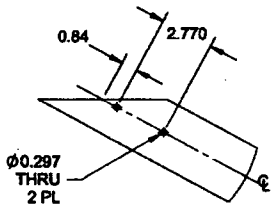


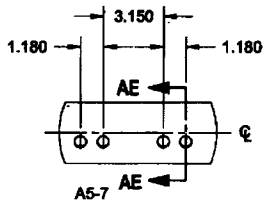
D2750-4 RH SKIDTUBE



MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



DETAIL AA D7-7
SCALE 2X



DETAIL AB C4-7
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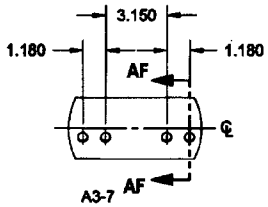
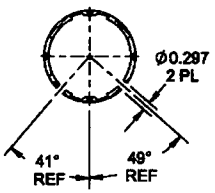
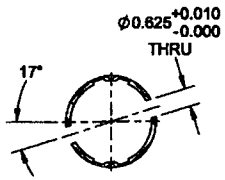


DETAIL AC D3-7
SCALE 2X



SECTION AD-AD D3-7
SCALE 3X, 17 PL



SECTION AE-AE B6-7
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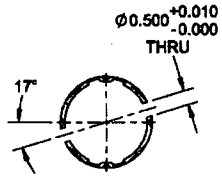

SECTION AF-AF B4-7
SCALE 3X, 4 PL

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DRAWN		
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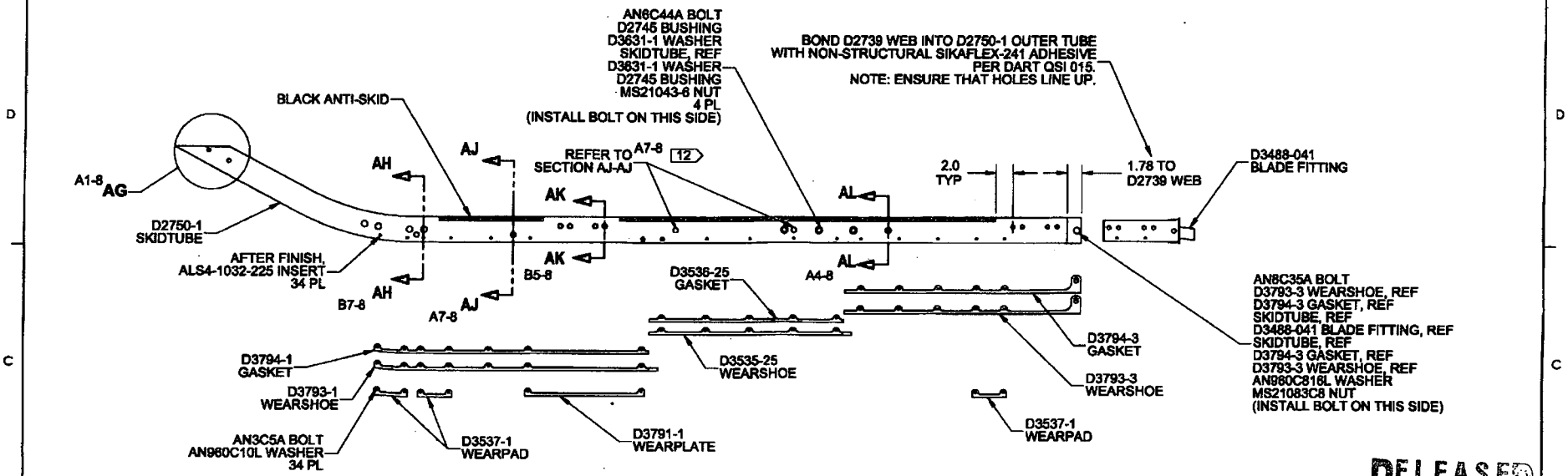

D2750-041 350 SKIDTUBE ASSEMBLY, LH

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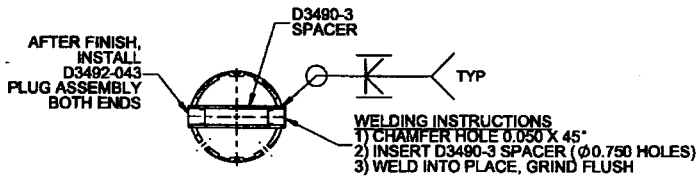
2013 -08- 13



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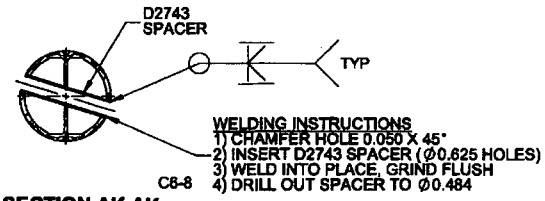

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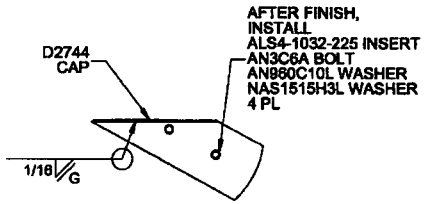
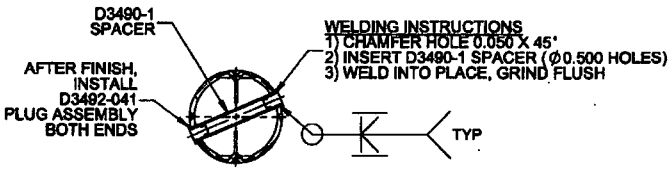
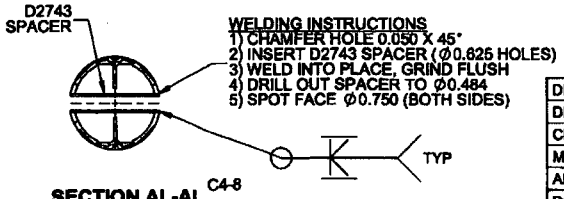


DETAIL AG
SCALE 2X
D8-8



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 8 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
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DATE	13.07.11	

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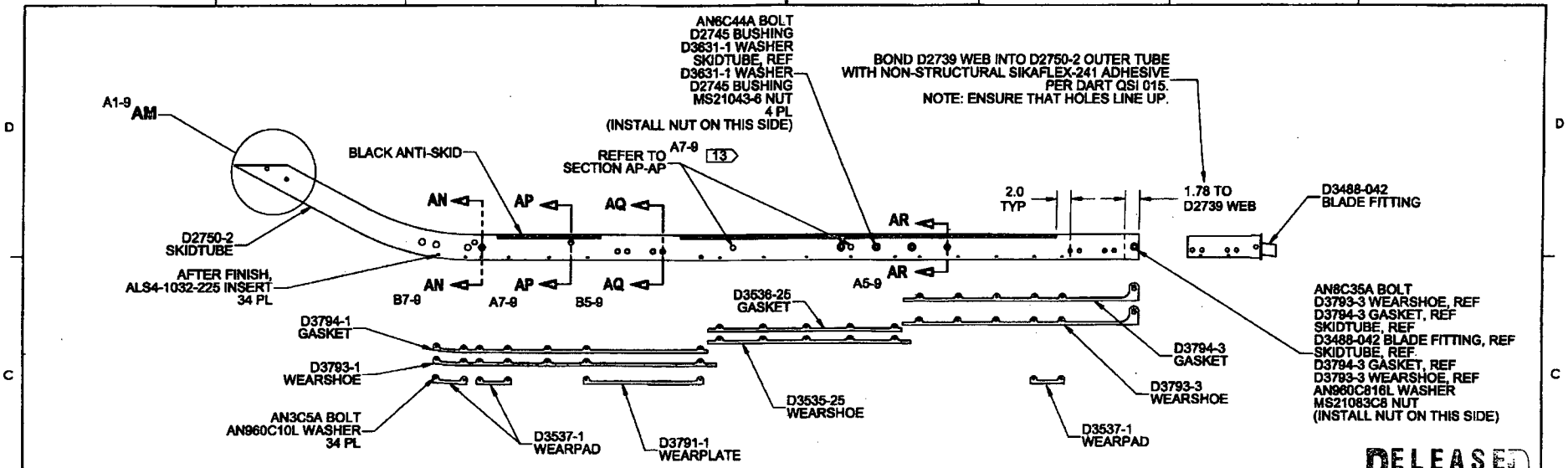
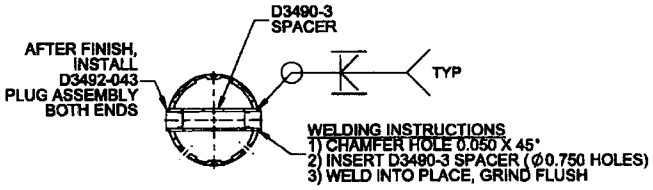
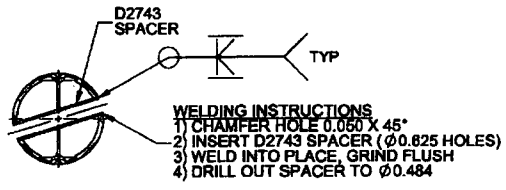


D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013 -08- 13



SECTION AN-AN C7-9
SCALE 3X, 4 PL



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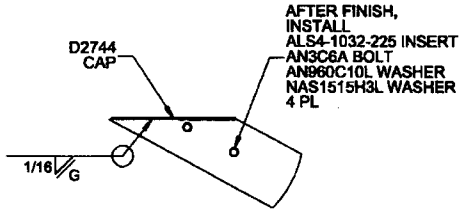

DETAIL AM D8-9
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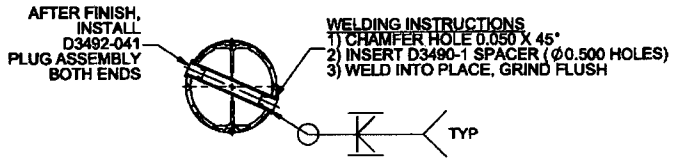

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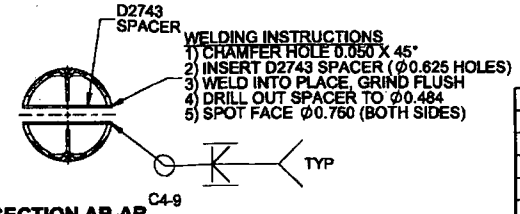

SECTION AR-AR C4-9
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 9 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE	13.07.11	

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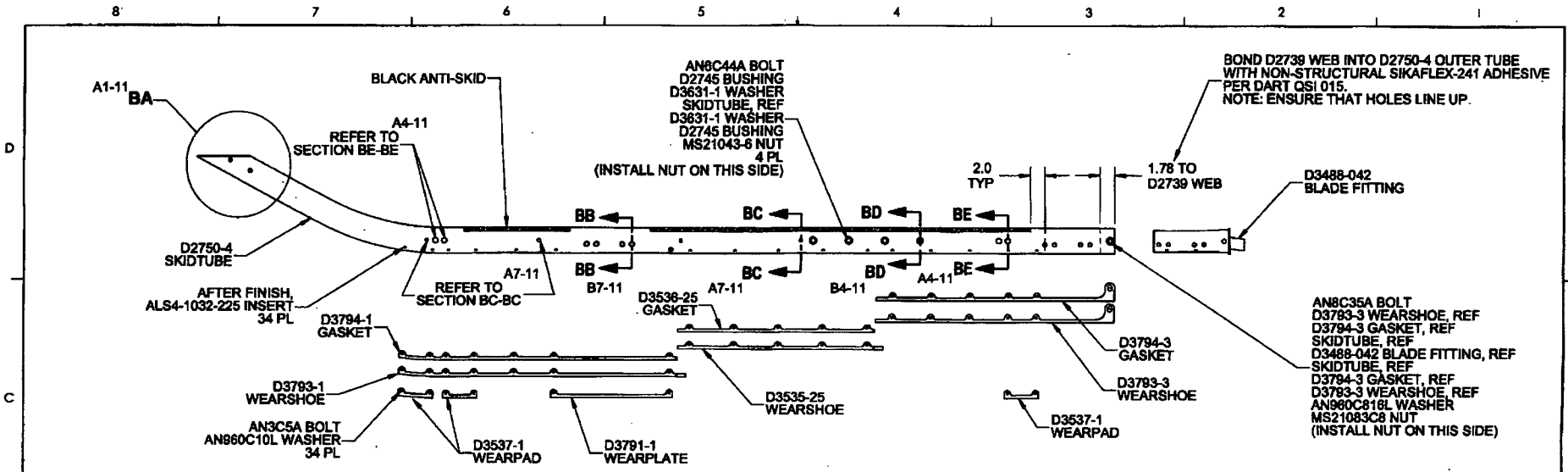
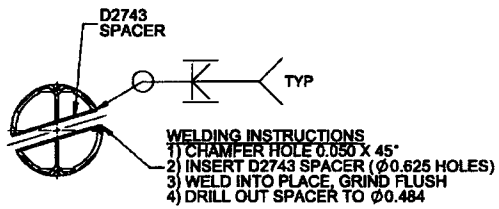


D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013 -08- 13



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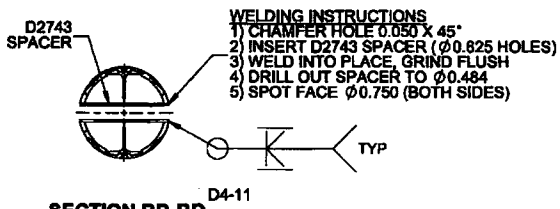

SECTION BD-BD
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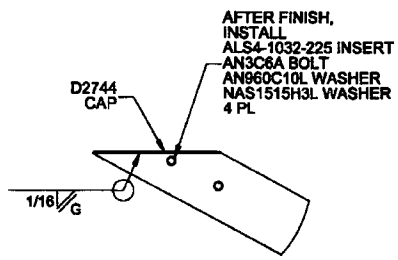
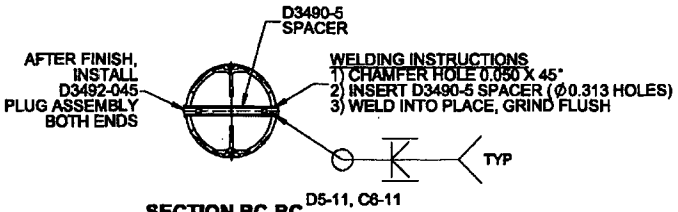


DETAIL BA
SCALE 2X



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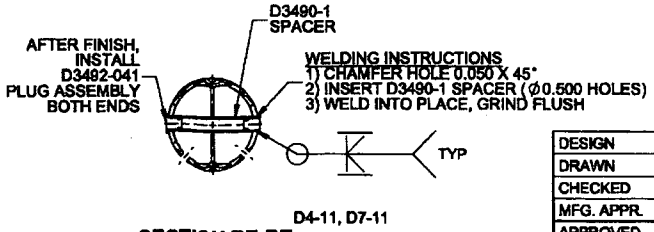

SECTION BE-BE
SCALE 3X, 4 PL

DESIGN	MM	DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. G — SHEET 11 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.07.11	

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No. 337

AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD

Name: Barclay Elliott

Job #: B110477

Part #: D350-636-012

Description: 350 skid tube

Welding Process: TIG [✓] MIG [ ]

Base Material: Aluminium

Current: AC [✓] DC [ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass [✓] fail [ ]
Penetration:	pass [✓] fail [ ]
Fusion:	pass [✓] fail [ ]
Cracks:	pass [✓] fail [ ]
Overlap (cold lap)	pass [✓] fail [ ]
Undercut:	pass [✓] fail [ ]
Pin holes:	pass [✓] fail [ ]
Porosity (surface):	pass [✓] fail [ ]
Coloration:	pass [✓] fail [ ]
Burn through:	pass [✓] fail [ ]

Qualifier: [illegible] **Date of Test Coupon:** 14-01-30

Welder: Barclay Elliott **Date of Test Coupon:** 14-01-30

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.